

Page 1

Quality Control

13-05-13

2

JB

DA
09
9-89

2

13-05-13

DA
09
9-89

2

13-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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NOTE: Date & initial all entries

77084

November-25-11 10:33:32 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 25/11/2011 **Start Qty:** 2.00

2

Customer:

Required Date: 09/12/2011 **Req'd Qty:** 2.00

2

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

Insp.
Stam.

160

Identify as per dwg & Stock Location:

0.00

160

Packaging

Memo

0.00

Packaging

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MF

13-5-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November-25-11 10:33:35 AM

Page 1

Work Order ID: 77084

77084

Parent Item: D3463-041

D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV. A 05.11.18 new issue EC IPP revB: replace pressure
with wing walk DD 10.01.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

238-806

Purchased

No

100

Each

64.0000

2

4

238-806

SS DOWEL PIN 1" LONG

**

13-05-09
JBL

Location

Loc Qty

Loc Code

ST399

64

[4]

117606

64

D3453-3

Manufactured

No

100

Each

12.0000

1

2

D3453-3

Clevis

**

13-05-09
JBL

Location

Loc Qty

Loc Code

WA

12

[2]

71900

4

73622

8

D3453-5

Manufactured

No

100

Each

11.0000

1

2

D3453-5

Plug

**

13-05-09
JBL

Location

Loc Qty

Loc Code

WA

10

[2]

73623

10

WA023

1

59204

1

D3463-1

Manufactured

No

100

Each

4.0000

1

2

D3463-1

Arm

**

13-05-09
JBL

Location

Loc Qty

Loc Code

WA

4

[2]

70855

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

November-25-11 10:33:35 AM

Page 2

Work Order ID: 77084

77084

Parent Item: D3463-041

D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

D3463-3 Manufactured No

100 Each

12.0000

1 2

D3463-3

Step

**

13-05-09
JBL

Location

Loc Qty

Loc Code

WA025

12

46269

12

2

D3463-5 Manufactured No

100 Each

21.0000

2 4

D3463-5

End Cap

**

13-05-09
JBL

Location

Loc Qty

Loc Code

WA

21

70819

21

4

D3463-7 Manufactured No

100 Each

1.0000

1 2

D3463-7

Drag Arm

**

13-05-09
JBL

Location

Loc Qty

Loc Code

WA025

1

70857

1

88429
92175

1
1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

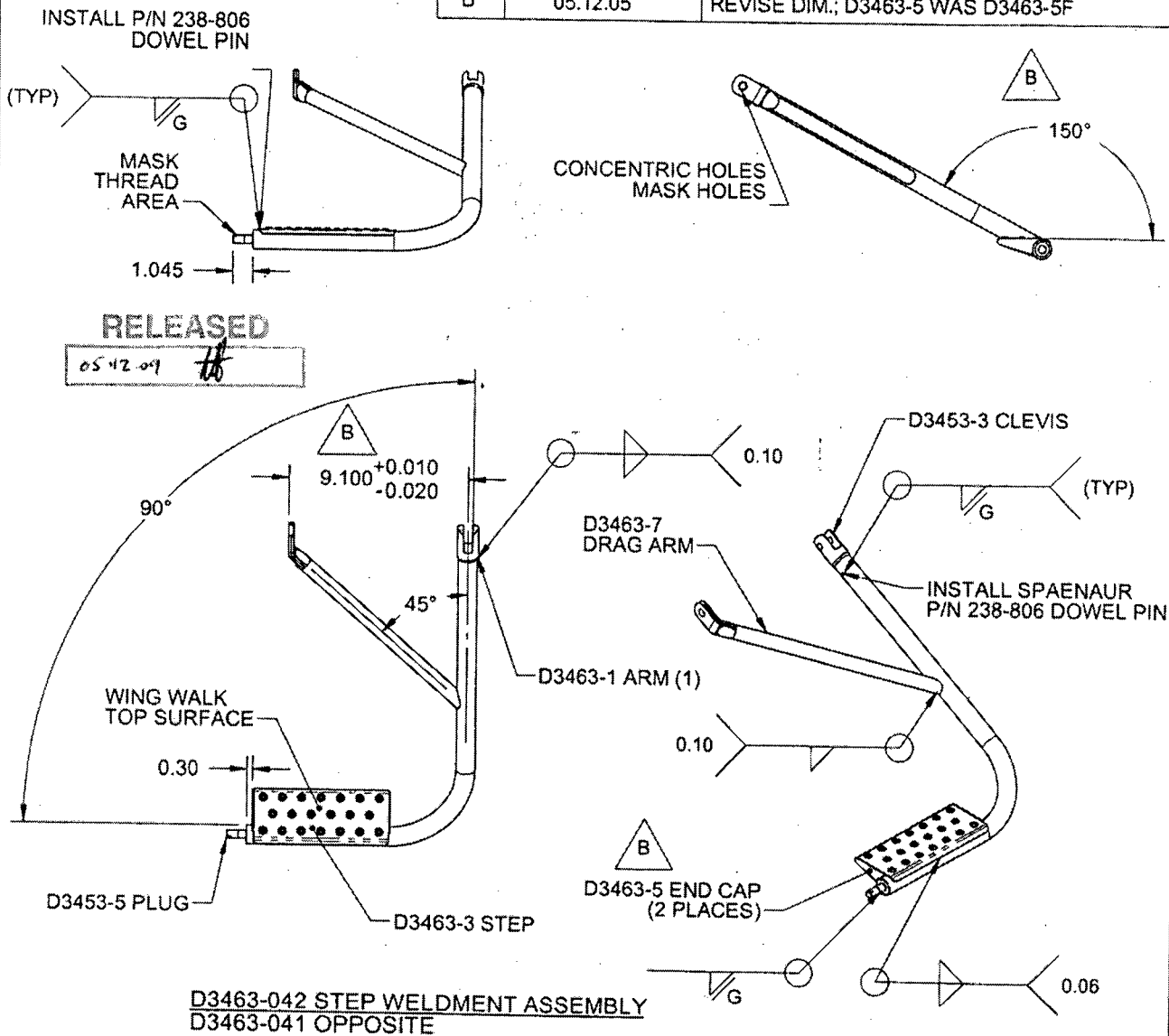
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **33084/ML-5**
11/11/25

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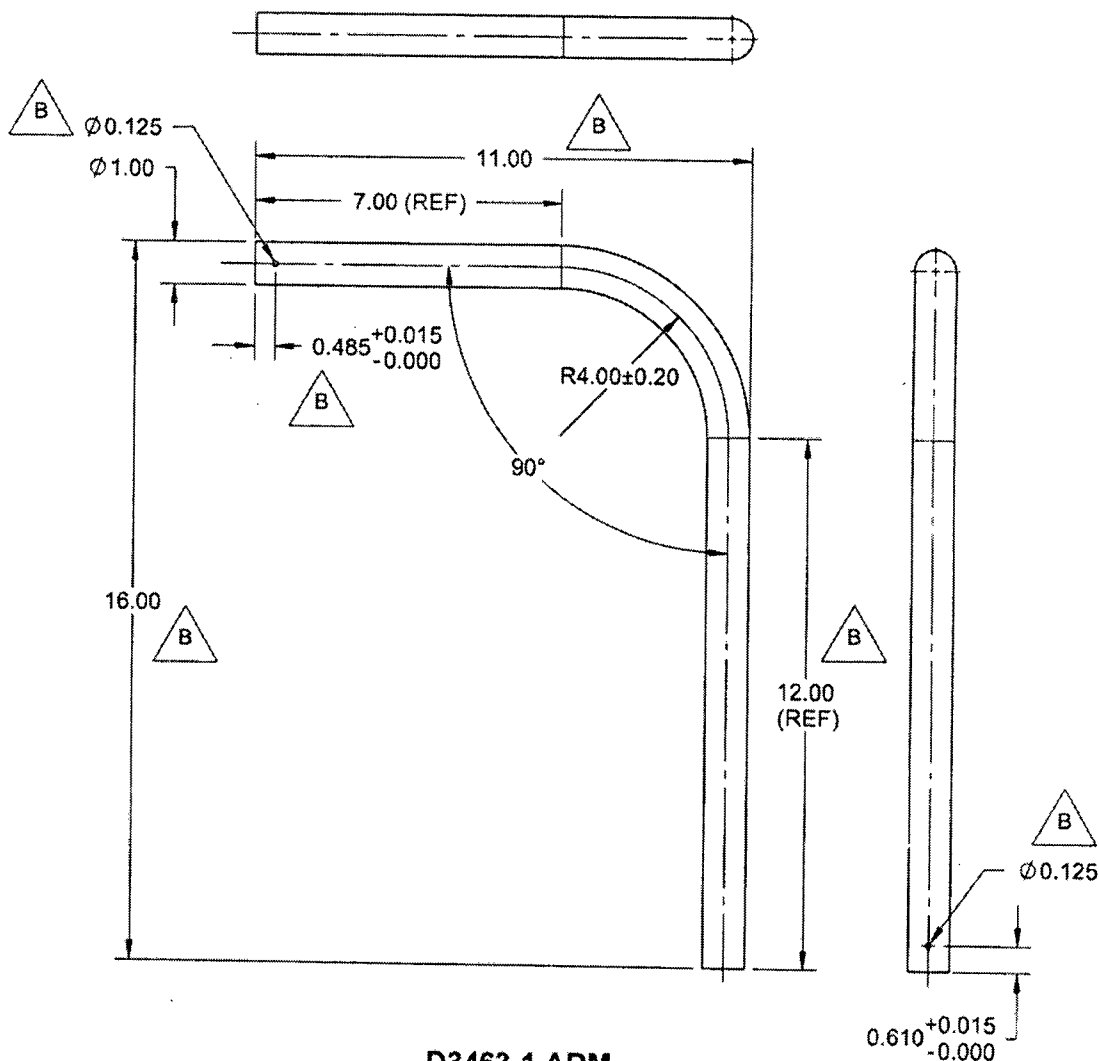


77084

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3463
DATE 05.12.05	TITLE STEP WELDMENT	REV. B SHEET 2 OF 4 SCALE 1:4

RELEASED

05.12.04



D3463-1 ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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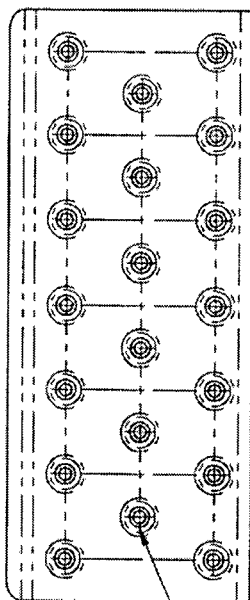
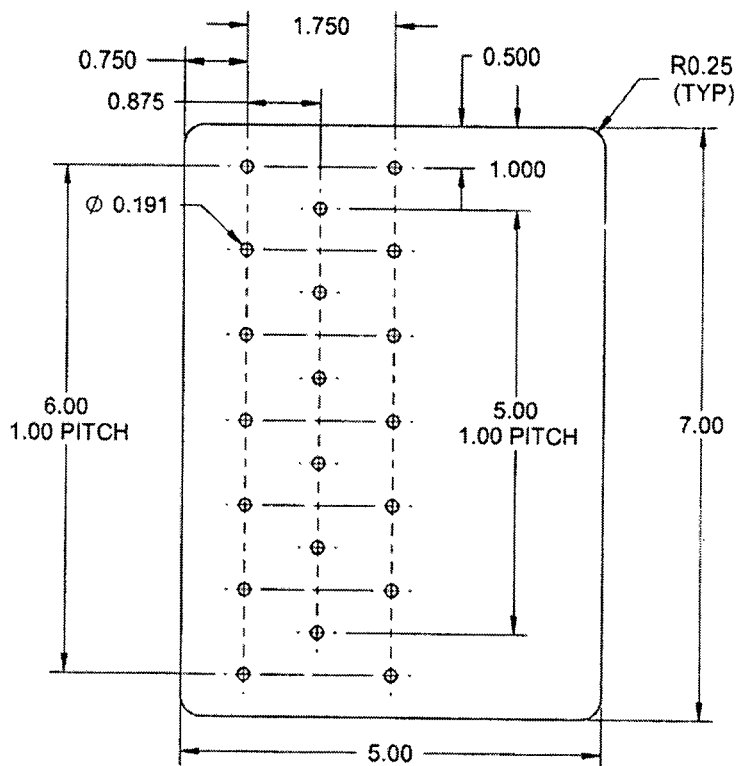
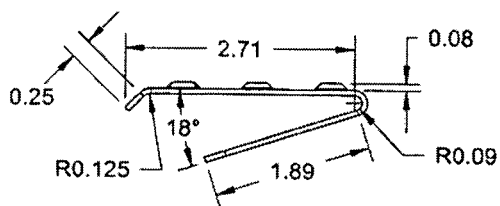
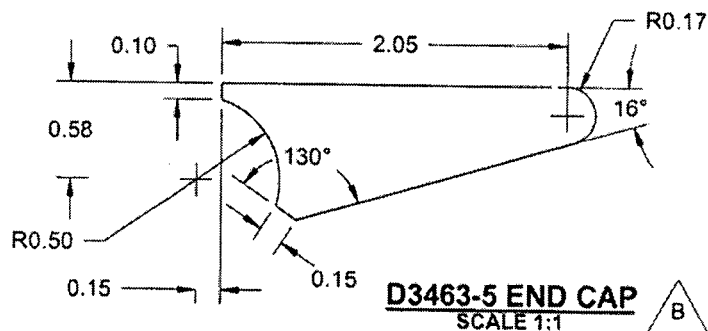
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

05.12.09 #

**FORM USING
D3463-3T1****D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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